

Date: Tuesday, 11/29/2005 11:23:53 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 24979	
Estimate Number : 10584	
P.O. Number : N/A	Part Number : D1048
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 24986	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 12/19/2005
Checked & Approved By : SEE COMMENT BELOW	Qty : 50 Um : Each
Comment : Est: B 02.02.22 Re-format NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 2000000184 20511129

Stamp and deburr per dwg D1048

Material: Stainless steel T304#2B Supply release not for Material.

2.0	D1048F	Clamp
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**Comment:** Qty.: 1.0000 U(s)/Unit Total: 50.0000 U(s)

CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C206101105

50

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

06-01-17 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

2-Form as per dwg D2010 using DT8053

SAD 06-01-21

FF 06-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 11:23:53 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 24979

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



206.01.25

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

ml 06 02 08

50

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 206102107

(50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 11

C 206102107

(50)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUE 06/02/08

(50)

SP 06/02/08

50

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 2D Date: 06/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02

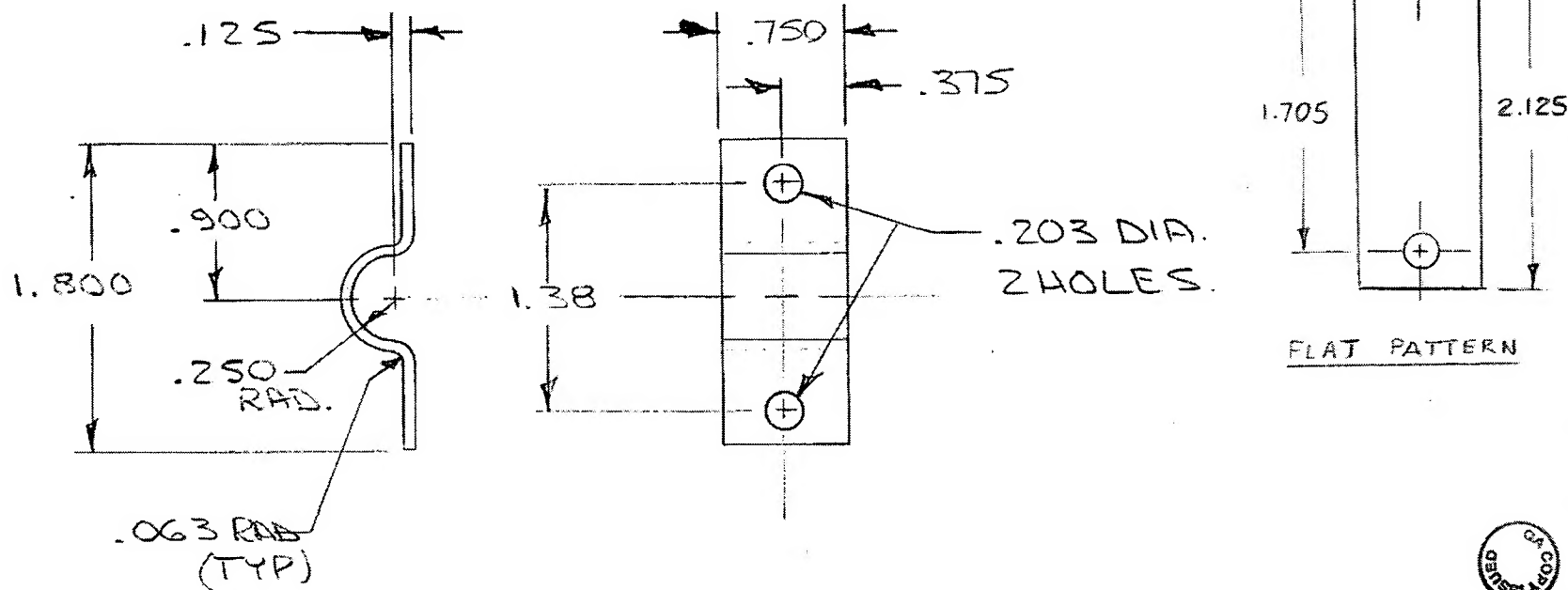
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



01.12.05 ADD FLAT PATTERN	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER MAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
	RF	DRAWN		BASIC CODE	DIA. DASH NO. H=HEAD NEAR SIDE T=HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA			
		APPROVED		Q=DOUBLE D=THICK OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN BRADLEY DATE 5/1/91					
	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISH SHALL BE 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. S. 3742 5. HOLES PER MIL 10387			FINISHES 1. TOLERANCES — .002 & .030 2. ANGLES 3° & 45° 3. PARALLELISM .005 MAX 4. PERPENDICULARITY .005 MAX 5. SYMMETRY ABOUT ALL MTC CENTRE LINES .005		BASIC CODES SPMSP04704D BB=MS20426AD		DESIGN BRADLEY STRESS CHECKED CLIENT		TITLE CLAMP CODE D1048 SCALE 1:1 SHT 1 OF 1	
REPORT ALL DISCREPANCIES — DO NOT SCALE											

D1048

A

90250188
INSPECTION CERTIFICATE
MATERIAL TEST/INSPECTION CERTIFICATES

YEH MAU CORP.

INVOICE NO.:
COMMODITY:

FORM 17
PREFERED ROLLER STAINLESS STEEL SHEET ANSI 304/304 (304)
FINISH WITH 160 MIC. FILM ON MAIN SIDE, WITH BACK FINISH,
SLITTED EDGE AND 304/304 FINISH WITH PAPER INTERLEAVED,
SLITTED EDGE.

SPECIFICATION:
CUSTOMER:

ANK 304
INTEGRIS METALS LTD

工廠:高雄路林樹順路345號
345 SHUN AN RD. LU CHU HSANG
KAOHSIUNG TAIWAN R.O.C.
TEL: (87) 3672005 FAX: (87) 3672008
CERTIFICATE NO: 90250188
DATE OF ISSUE: 08/19/2004

(ITEM NO) SIZE	NO.	Weight (L.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)								
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
ANSI 304 2B (7425-4228)																			
12GA/48"X120" (7425-5551)	1	1,473	3,247	YU132583	34321644B-4	285	608	58	81	150	3.9	49	115	24	4	807	1827	3.2	
12GA/48"X120" (7425-5510)	1	1,445	3,186	YU228949	34321939B-5	280	600	57	80	158	4.2	48	118	24	5	828	1828	2.8	
12GA/48"X120" (7425-5604)	1	1,457	3,212	YU228245	35522525A-3	285	635	64	82	160	4.6	48	126	30	3	815	1827	2.5	
12GA/48"X120"	1	1,435	3,164	YU131655	35522522A-2	312	684	64	83	163	4.5	48	107	32	7	812	1834	2.2	
12GA/48"X120" (7425-5659)	1	1,435	3,164	YU131633	35522522A-3	312	684	64	83	163	4.5	48	107	32	7	812	1834	2.2	
12GA/48"X120" (7425-5659)	1	1,414	3,117	YU131655	35522522A-4	312	684	64	83	163	4.5	48	107	32	7	812	1834	2.2	
12GA/48"X120" (7425-5659)	1	1,480	3,263	YU228928	35523008A-4	277	605	64	77	145	4	47	112	28	4	821	1815	2.8	
12GA/48"X120" (7425-5677)	1	1,437	3,165	YU229031	35522903C-5	296	600	53	82	160	4.2	49	114	32	5	810	1813	1.7	
12GA/48"X120"	1	1,430	3,153	YU132680	35523001B-11	281	637	55	80	154	4.4	50	113	30	5	801	1811	2.8	
12GA/48"X120" (7425-5680)	1	1,430	3,153	YU132680	35523001B-9	281	637	55	80	154	4.4	50	113	30	5	801	1811	2.8	
12GA/48"X120" (7427-3501)	1	1,391	3,067	YU132680	35523001B-12	281	637	55	80	154	4.4	50	113	30	5	801	1811	2.8	
12GA/48"X120" (7427-3502)	1	1,465	3,230	YU228945	35523007A-12	308	655	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120"	1	1,371	3,023	YU228945	35523007A-13	308	655	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120"	1	1,375	3,031	YU228945	35523007A-14	308	655	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120" (7427-4127)	1	1,375	3,031	YU228945	35523007A-15	308	655	53	83	165	4.9	45	108	24	5	817	1824	3.1	
12GA/48"X120"	1	1,423	3,137	YU132689	35523083A-11	294	646	53	82	161	5.2	51	115	31	3	802	1823	2.8	
		1.6	22.35	50.345															
Remarks:		NO MERCURY CONTAMINATION				Send test good for all Heat NO.													
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN MEETS ALL																			

NO MERCURY CONTRIBUTION
GENUINELY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Product in accordance with ASTM A240, A480,
A302E, ASME SA240, QQ37880.

YEH MAU CORP.

Lin Kim Hsing
Manager of Quality Assurance Section

1694 304 #4
#26 finish ✓

206-01-17

1004 186 154 1416